

Ing ASAP 11/01 - 12/01

Work Order ID 65102



Page 1

January 6, 2011 10:38:01 AM

Item ID: D3017-041

Accept



Setup Start



Revision ID:

Item Name: Back Frame Assembly

Stop



Start Date: 1/06/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/11/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3017

Rev B

100



Large Fab

Large Fab

Weld per dwg A/R 4130 rod Batch: *100075* 0.00
Large Fab

Memo

0.00

1-Cut D3017-1, D3017-3 and D3017-5 tubes as per Dwg D3017

2-Bend D3017-1 and D3017-3 tube as per dwg D3017 (DT8598)

3-Drill holes in D3017-5 Using DT8622

4-Deburr

5-Assemble and weld as per Dwg D3017 using Welding Jig DT8598

6-Drill holes in back frame using DT8621

BE *11-1-10* *(Signature)*

110



QC

Quality Control

QC9- Inspect visual per QS1004- Fusion Welds 0.00

Memo

0.00

BE *(Signature)* *1/10/10*

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

8 n/a

QC

Memo

0.00

Quality Control

130

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M112588

0.00

2) JM n/a

Powdercoat

Memo

Powder Coating

START TIME: 1:30pm
OVEN TEMPERATURE: 320°F
FINISH TIME: 2:00pm

140

QC3- Inspect Part Finish

0.00

0.00

QC

Memo

Quality Control

1/11/11

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Required Date: 1/11/11 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

PAP
65102

0.00

11/01/11

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/01/12
MF
11-01-11

W/O:		WORK ORDER CHANGES					
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Picklist Print

January 6, 2011 10:38:00 AM

Page 1

Work Order ID: 65102



Parent Item: D3017-041



Parent Item Name: Back Frame Assembly

Start Date: 1/06/11

Required Date: 1/11/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A001.09.19 New issue EC
IPP RevB: as per revB DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M4130NT0.750W.083

Purchased

No

100

f

11.5000

2.458

2.587368



4130 RD Tube .750 x.083W

Location

Loc Qty

Loc Code

MAT33

11.5

113812

11.5

2.5

M4130NT0.750W.049

Purchased

No

100

f

117.4167

11.125

11.71053



4130 RD Tube .750 x.049W

Location

Loc Qty

Loc Code

MAT033

117.4167

10133

13

110740

104.4167

12.875

D3017-11

Manufactured

No

100

Each

21.0000

2

2



cap

Location

Loc Qty

Loc Code

WA

21

52583

21

4

D3017-7

Manufactured

No

100

Each

19.0000

3

3



Lug

Location

Loc Qty

Loc Code

WA

19

58567

2

52915

17

3

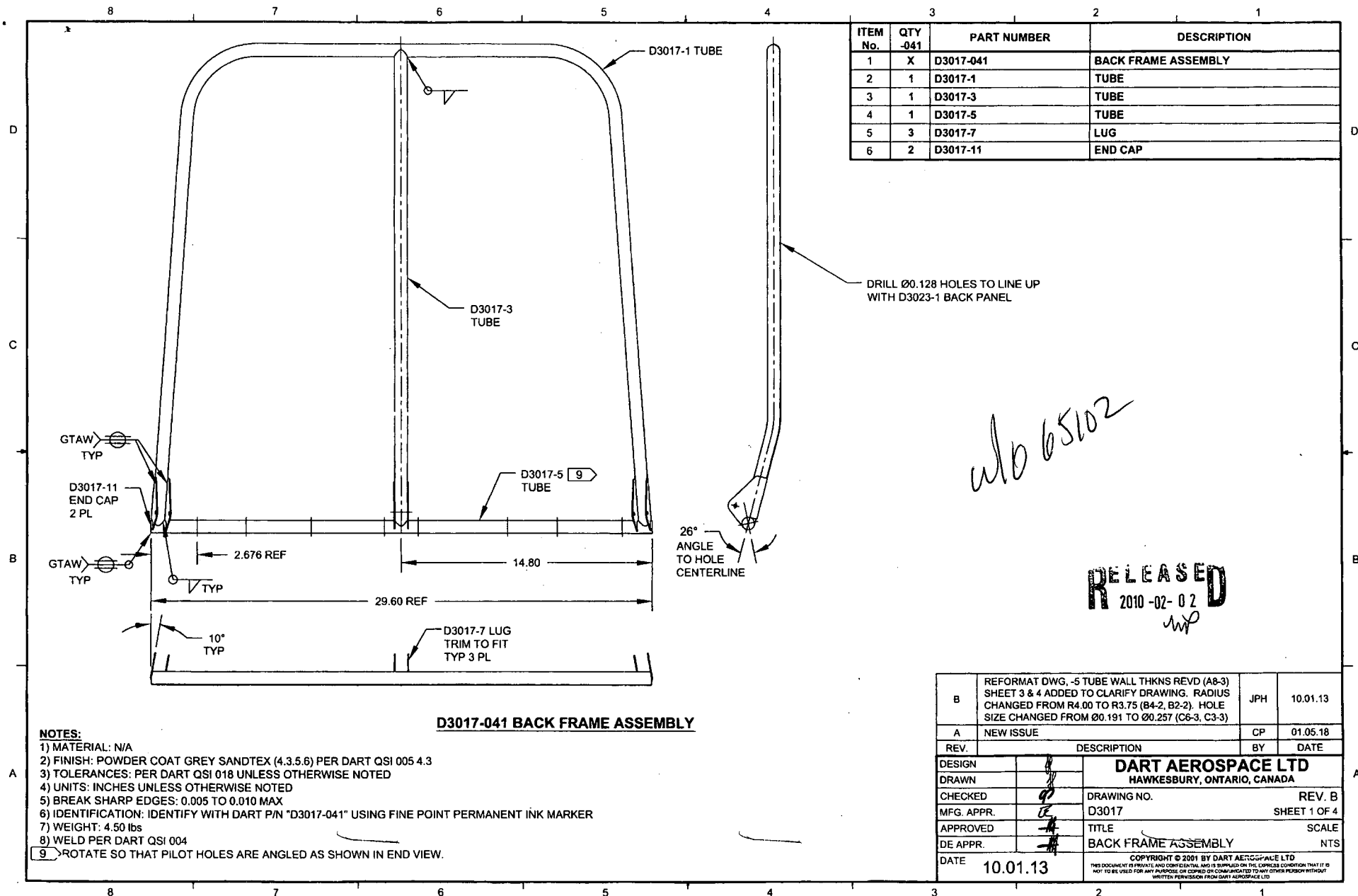
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ITEM No.	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3017-041	BACK FRAME ASSEMBLY
2	1	D3017-1	TUBE
3	1	D3017-3	TUBE
4	1	D3017-5	TUBE
5	3	D3017-7	LUG
6	2	D3017-11	END CAP

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3017-041" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 4.50 lbs
 - 8) WELD PER DART QSI 004
 - 9) ROTATE SO THAT PILOT HOLES ARE ANGLED AS SHOWN IN END VIEW.

D3017-041 BACK FRAME ASSEMBLY

B	REFORMAT DWG, -5 TUBE WALL THKNS REVD (A8-3) SHEET 3 & 4 ADDED TO CLARIFY DRAWING. RADIUS CHANGED FROM R4.00 TO R3.75 (B4-2, B2-2). HOLE SIZE CHANGED FROM Ø0.191 TO Ø0.257 (C6-3, C3-3)	JPH	10.01.13
A	NEW ISSUE	CP	01.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.01.13		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3017
TITLE BACK FRAME ASSEMBLY
REV. B
SHEET 1 OF 4
SCALE
NTS

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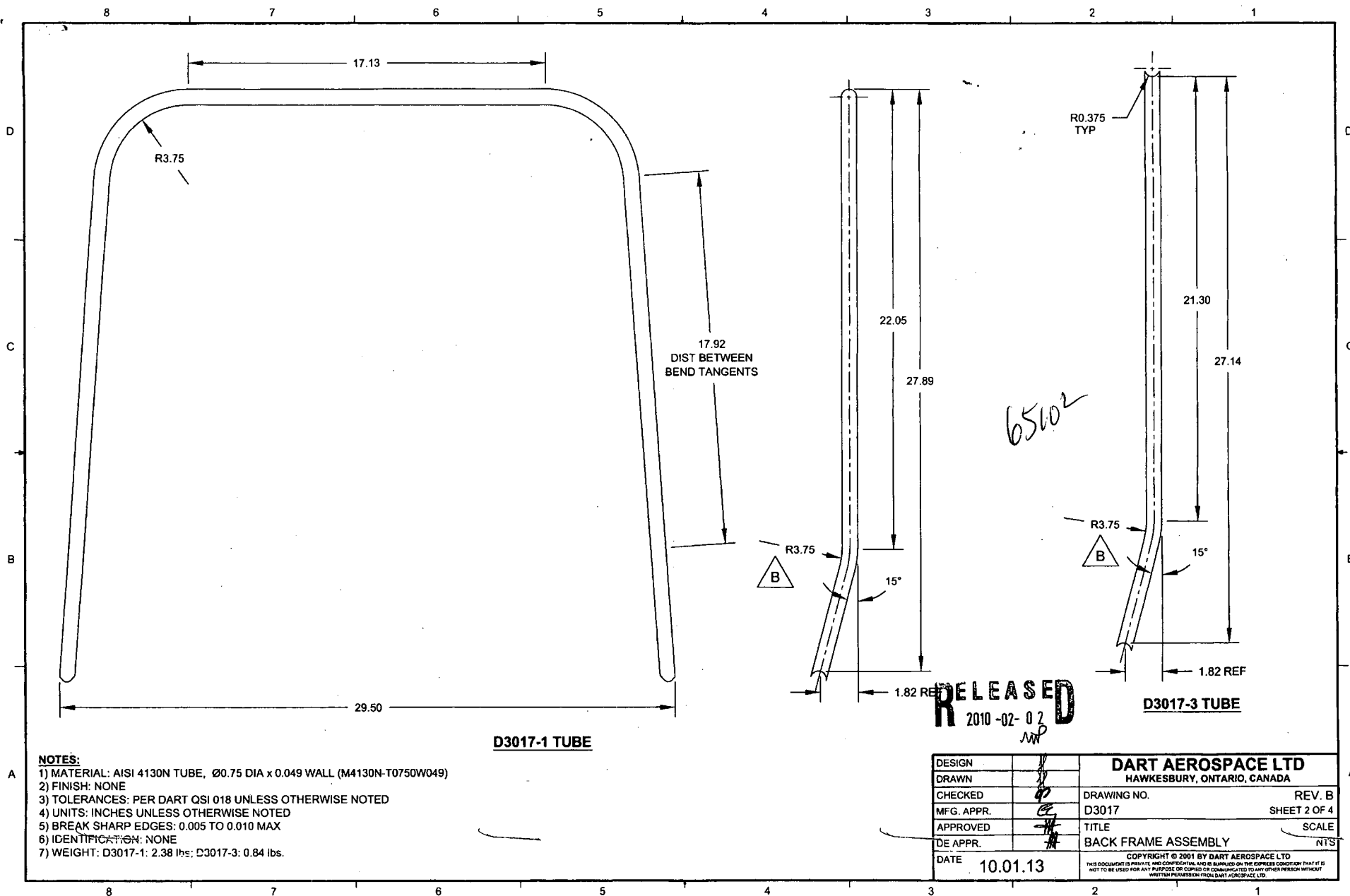
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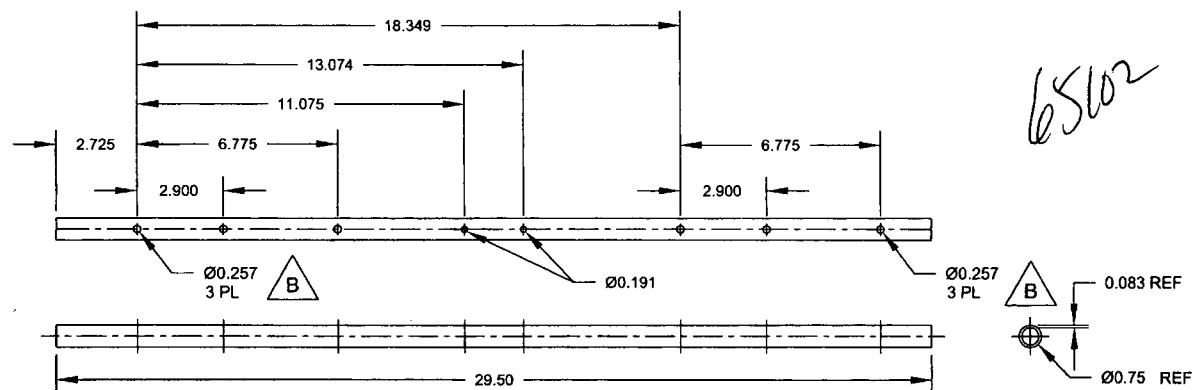
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D3017-5 TUBE

RELEASED
2010-02-02
AMP

NOTES:

- 1) MATERIAL: AISI 4130N TUBE, $\varnothing 0.75$ DIA x 0.083 WALL (M4130N-T0750W083)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.89 lbs



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MFG. APPR.		D3017	SHEET 3 OF 4
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8 7 6 5 4 3 2 1

D

D

C

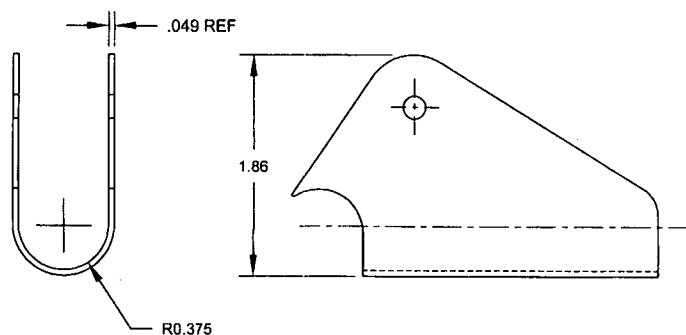
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B

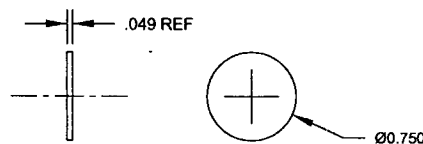
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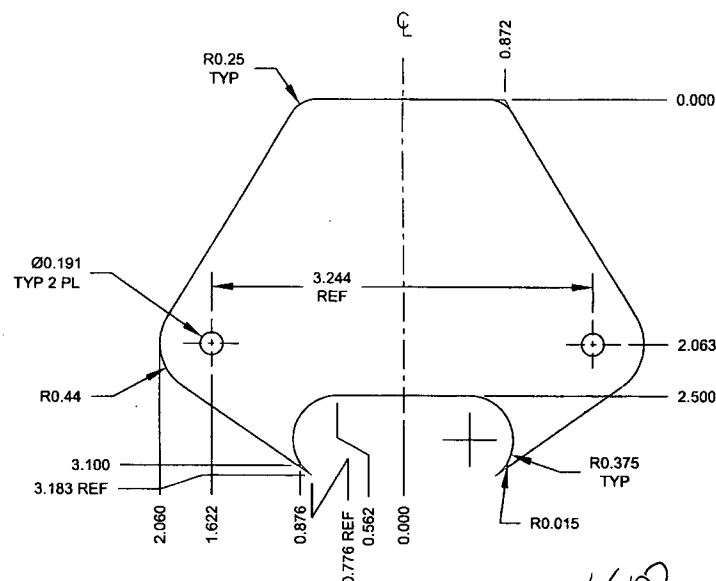
A



D3017-7 LUG
BENDING DETAIL
MAKE FROM D3017-7F



D3017-11 END CAP



D3017-7F FLAT PATTERN
PART IS SYMMETRIC
ABOUT CENTERLINE

65102

RELEASED
2010-02-02

- NOTES:**
- 1) MATERIAL: AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: -7: 0.12 lbs; -11: 0.01 lbs.

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8 7 6 5 4 3 2 1